

PHA Findings

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ABU	Plant	Revalidation	Start Date	End Date	Facilitator	Scribe
Isomax	H2SNR	2nd Revalidation	5/11/2005	5/13/2005	Steve Aakhus, AcuTech Consulting Group	Steve Aakhus

Core Team Members / Role

Brent Parker – Process Engr. John Radcliffe – OPS Madan Arora – Design Engr

Close Out Meeting Participants / Role

Additional Participants / Role

Entire PHA Report

*** Further discussion about any portion of the report and its contents should be directed to the facilitator or any of the team members listed**

Comments

Reviewed By	Date	Feedback/Comments
B Crew	03/14/2006	
C Crew	03/08/2006	
Other Individual	11/22/2005	mtbr

Section No Section Description

41 A TRAIN -. B TRAIN - K-360E, K-360W, K-361E, and K-361W

Item	WhatIf	Deviation	A/C	SOE	RR	ABU Proposal	Resolution	Owner	Due By	Status
41-7	16312	Miscellaneous	Concern: Continued operation with "swirling natural gas" may result in a significant furnace tube damage and downtime. Consider expediting the ongoing burner tip study for mitigating burner swirl. S - 3-4-5 O - 3-2-3	S	5	Would like to have Furnace expert Ed Shepherd look at F-355 and make recommendation on whether new burners would make a difference or if other alterations are necessary to improve furnace operation. Resolution: After consultation with Ed Shepherd (furnace expert), found that	A/C is complete. No further studies are required, study with Ed L. Shepherd is done.	Capshaw, Michelle	9/15/2006	Completed

Nox burner design causes the increased flame size & swirling issues, but that the actual flame temperature is lower than before. The swirling looks bad, but will not cause any damage to the furnace tubes. The tubes are the highest metallurgy for this type of service, and temperatures in the furnace are below that which would cause problems with the tubes. Visual inspection of the tubes shows some deposits on the tube which look like corrosion of the tubes themselves, but which are not. Instead, they are carbon from the fuel gas laying down on the outside of the tubes (insulating the tubes, not corroding them). This A/C is considered complete with no further actions required.

Section No Section Description

46 MEA from E-337's Through E-333's and P-332 & A up to Inlet of E-334A

Item	WhatIf	Deviation	A/C	SOE	RR	ABU Proposal	Resolution	Owner	Due By	Status
46-1	16314	No Flow	Concern: Spare pump repairs require multi-week turnarounds due to lack of long delivery spare parts. 2005: Consider evaluating the spare parts inventory criticality and maintaining a supply of critical spare parts to reduce repair turnaround.	S	4	The ABU has upgraded two of the pumps to stainless steel for higher reliability. The ABU has decided to purchase an additional spare pump, upgraded as well to stainless steel. This upgraded pump will act as a common spare for both of the MEA pumps.	A meeting was held to discuss purchasing a spare stainless MEA pump for the H2 trains. In the meeting the decision was made not to purchase a spare pump because of the increased reliability of the two in place. A decision was made to have all spare parts and seals in stock if one of the pumps failed.	Aberin, Romeo B.	3/30/2006	Completed

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